

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027830**Date Inspected:** 25-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** William Sherwood**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of the shift this Quality Assurance Inspector (QA) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) welding and Quality Control (QC) personnel. The observations and inspections were performed as noted below:

QAI randomly verified and QC recorded the preheat to 150F of deck plate splice W13-W14-W121.6. The proper preheat is being obtained by use of induction heating blankets located on the top of the bridge deck plate. The preheat temperature is being checked by Tempil Sticks.

This QAI observed welder Mike Jiminez (ID#4671) welding W13-W14-W121.6 utilizing the Shield Metal Arc Welding Process, in the 4G position, at a QC recorded QA randomly verified, 125 amps. The verified 125 amps are within the parameters of the applicable Welding Procedure Specification ABF-WPS-D15-1040C-CV. Mr. Jiminez is using a power wire brush and chipping hammer to remove slag after each pass.

This QAI observed the preheating by rosebud torch of floor beam splice 13W-PP124.5-W2.2-BF1 by welder Jeremy Doleman (ID#5042). This QAI observed the welder and QC Inspector William Sherwood measuring and recording preheat at 150F with a Tempil Stick.

This QAI observed Welder Jeremy Doleman (ID #5042) welding 13W-PP124.5-W2.2-BF1 utilizing the Shield Metal Arc Welding Process in the 1G position at a QC recorded QA verified 137 amps. The verified 137 amps are within the parameters of the applicable Welding Procedure Specification. Strong backs tacked to the underside of the above-mentioned weld joint are being left in place while the topside of the weld joint is being welded.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

QAI witnessed the welding of stiffener plate PP120-TS1 by welder Tran Chau using the Shield Metal Arc Welding Process to the parameters of Welding Procedure Specification ABF-WPS-D15-1030. The welder was using the stringer technique and using a power wire brush to clean between passes. This QAI noted QC Inspector William Sherwood documenting welding parameters.



Summary of Conversations:

There were general conversations with Quality Control Inspector William Sherwood, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift. All observations were relayed to Danny Reyes and Bill Levell.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510 385 5910, who represents the Office of Structural Materials for your project.

Inspected By:	Daggett, Matt	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
